

Date: Friday, 17/10/2008 12:43:38 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY (350)
Job Number	: 42721A		
Estimate Number	: 10189		
P.O. Number	:	Part Number	: D2221
This Issue	: 17/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2221 REV G
First Issue	: 11	Project Number	: N/A
Previous Run	: 42630C	Drawing Revision	: G
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 05/11/2008
Checked & Approved By	: <u>JUD 08.10.17</u>	Qty:	1 Um: Each
Comment	Est Rev:J 05.09.02 Added D3442-1 KJ/JLM Est Rev:K 08-08-29 revG as per dwg DD verified by:EC Est Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D3166-1	RIB	<u>B 43165</u>

EB SAD 08-12-18 (D)

2.0	D22323	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2232-3	Hinge bracket	<u>339334</u>

PL08.07.05

3.0	D2325	Support Gusset (350 Basket)
-----	-------	-----------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D2325	Support Gusset	<u>339913</u>

PL08.12.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/10/2008 12:43:39 PM
User: Julie Dawson

Process Sheet

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Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 42721A

Part Number: D2221

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2327-3 Bushing

B39560

P108.12.29

5.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket

B43800

P108.01.05

6.0	D34421	Shim
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim

B40392

P108.01.05

7.0	M304EX07516F	Expanded Metal Flat SS
-----	--------------	------------------------



Comment: Qty.: 41.6745 sf(s)/Unit Total: 41.6745 sf(s)

Pick:

Qty Part Number Description Batch

39.69 sf M304EX0.75-16F Expanded Metal

M110134

SAD 08-12-31

①

8.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 29.4000 f(s)/Unit Total: 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.065 wall 304/316 SS tubing

Batch: M109731 (20)

M110011 (9.4)

SAD 08-12-18

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Seq. #: Machine Or Operation: Description :

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Plug holes in D2581 prior to powder coating

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 07/01/08 @

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/12 J

Job Completion



MF 09-01-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

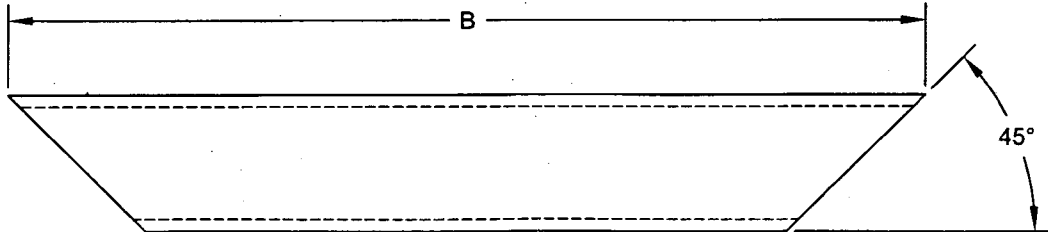
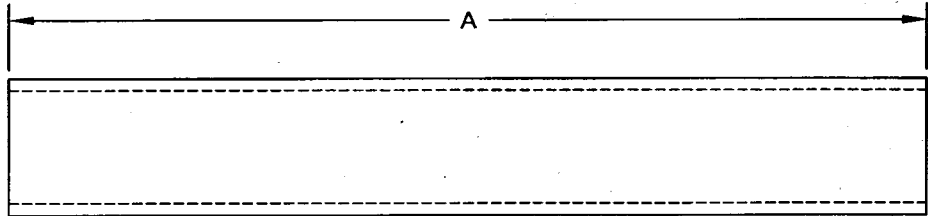
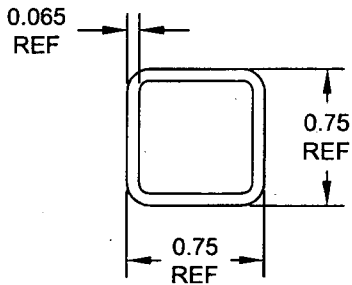
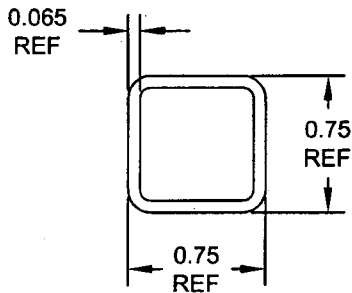
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	_____	96.00	RIB
D2221-3	2	_____	25.50	RIB
D2221-5	2	18.88	_____	RIB
D2221-7	1	55.25	_____	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D3442-1	2	N/A	N/A	SHIM



D2221-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

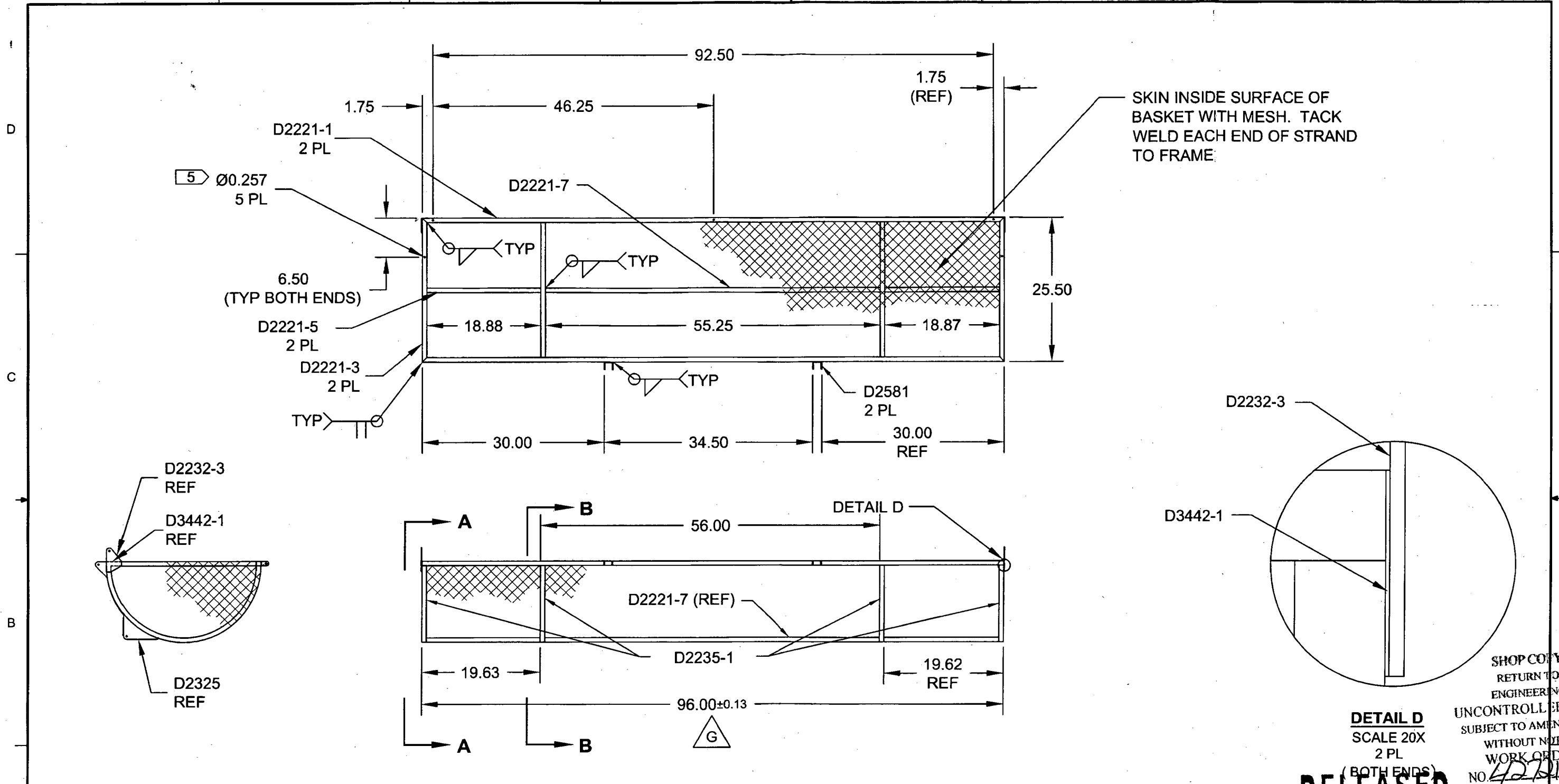


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G	MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 2 ZN B, 5 TOLERANCE FOR 96.00 DIM WAS +/- 0.01, 56.00 DIM WAS REF. SHT 2 ZN B4 19.62 DIM WAS "HARD" DIMENSION IS NOW REF. NOTE 5 TRANSFERED FROM SHT 1 TO SHT 2. SHT 2 MESH MATERIAL UPDATED. DRAWING TRANSFERED TO "B" FORMAT.	AJS	08.06.16
F	ADD SHIM UNDER HINGES. ADD HOLES FOR SPLIT LID BASKETS	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPERATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2221	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.06.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



D2221 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2221	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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7

6

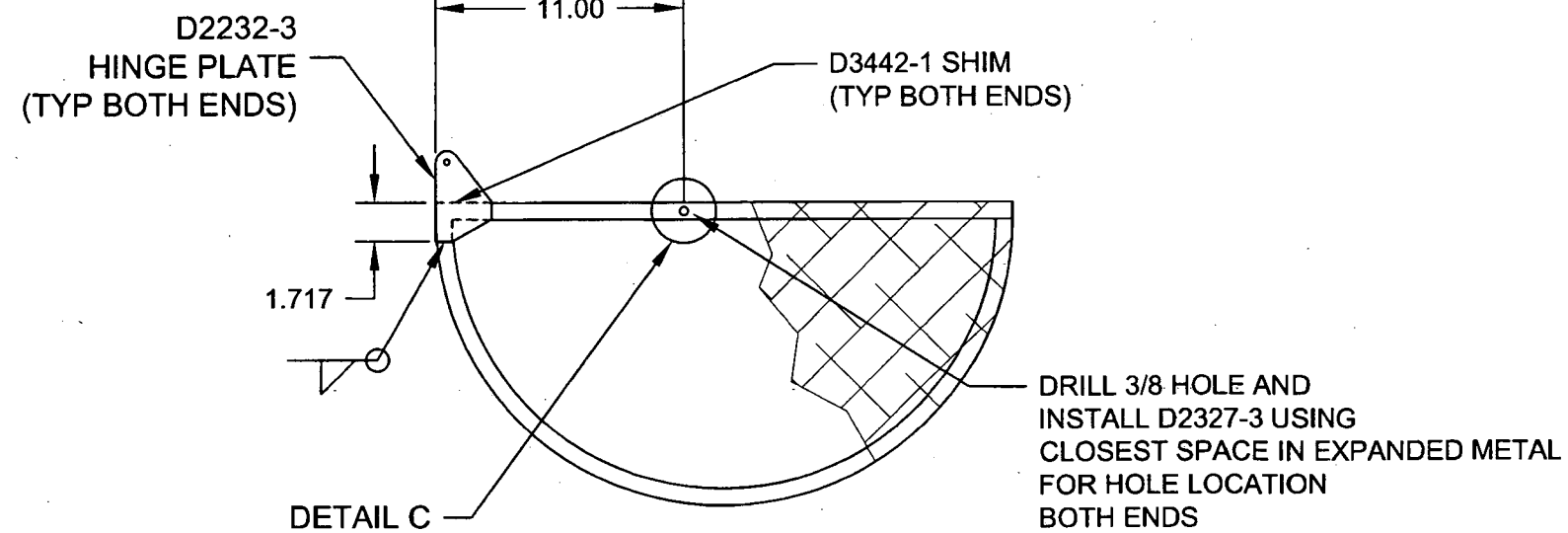
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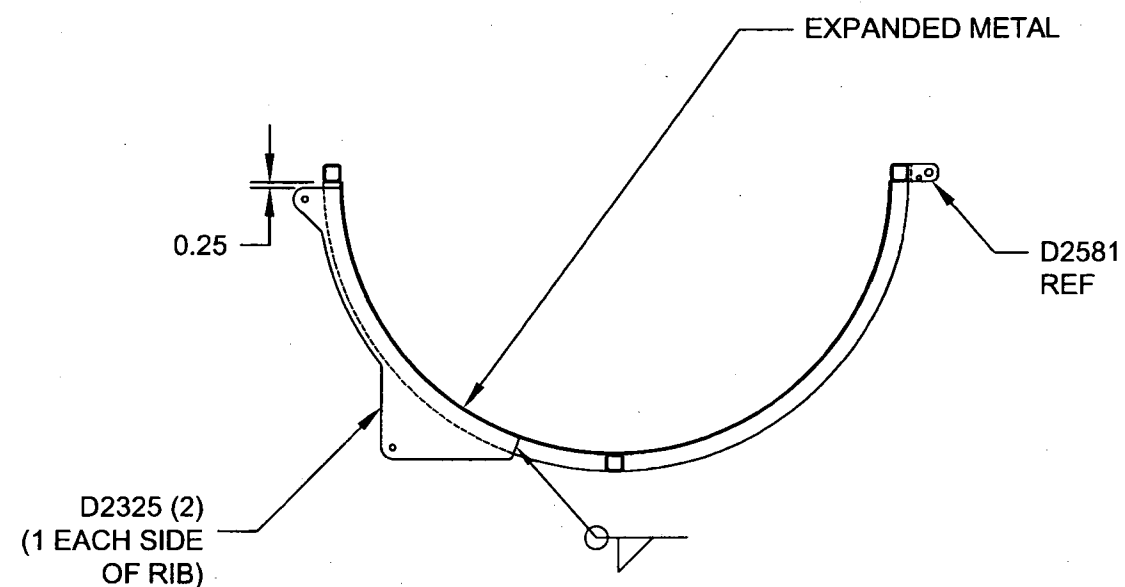
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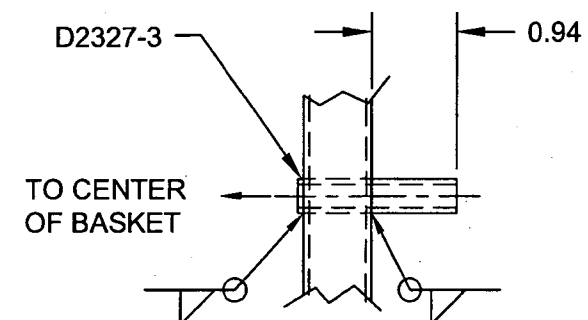
1



SECTION A-A SAME BOTH END RIBS



SECTION B-B SAME BOTH CENTER RIBS



DETAIL C
SCALE 4X

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18-08-27/11

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DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2221	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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